

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028017**Date Inspected:** 19-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower Shear Plate ESW (Observation of excavations, repair welding, QC inspection and testing).

Doug Frey-OBG E12, Corner Drop-In Assembly (Observations of welding, fit-up and QC inspection of the field splices) and OBG E5 (Observation of repair welding and QC inspection of deck access hole)

Rodney Patterson-Tower/Shear Plates (Research excavation of ESW/Shear Plates identified as "B" & "C").

William Clifford-Tower/Shear Plates (Ultrasonic testing of ESW).

Matt Daggett-OBG W13 (Observations of the welding and QC inspection of the structural steel members) and W13 Corner Drop-In Assembly (Observation of the welding and QC inspection of the deck field splices).

Fritz Belford-Tower/Shear Plates (Ultrasonic testing of ESW).

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NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Doug Frey, Rodney Patterson, Matt Daggett and Fritz Belford monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted during this shift.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies. This QA Lead Inspector also reviewed RWR documents for tracking purposes.

Inspection Request of OBG Splice Plates @ Pier 7

This QA Lead Inspector (QALI) verified various splice plates received from L & M Fabricators located in Camby, Oregon. These material was shipped to the contractor with the field release performed at Pier 7 as per Structural Materials Representative (SMR) Bahjat Dagher. This field release was requested by Quality Control Manager Chuck Kanapicki. This QALI verified the material of various sizes and shapes which were identified with a unique assembly marks. This material is to be utilized as stiffener plates, diverter plates, shim plates, splice plates, connection plates and fill plates. This QALI noted that shim plates identified as PP122-A & B, X3810d and X3860d required the removal of burrs at the drilled holes. This work was performed completed during the presence of this QALI. At the conclusion of the field release, this material and the associated documentation appeared to comply with the contract specifications.

This QALI generated an TL-29 Report on this date.

Summary of Conversations:

At the start of the shift, there were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

Also, there were pertinent conversations with QA Supervisor, William Levell, through the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and weld issues. There were no significant issues noted on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Reyes,Danny	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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